

# Product Data



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## HK Research Low HAP Gel Coat Spray Patch Procedure

### Materials:

- HK Research I0600 “Speed Thin®” Patch Additive
- HK Research I8517 “Copper Coat®” Surface Coat
- “Touch-up” spray gun
- MEKP-9, Norox 46-702, Akzo L-50A Organic Peroxide
- Graduated plastic cups\*
  - 150 ml
  - 400 ml
- Graduated plastic eye dropper\*\*
- DA sander
- DA paper in 150, 240, 500, 800, 1000 grits (or equivalent paper for hand sanding)
- Variable speed electric buffer
- Clean 100% wool buffing pad
- Virgin Acetone
- 3M “Imperial” Compound and Finishing Material. Part no. 06044
- Tongue Depressors (stir sticks)
- Heat Gun

### Procedure:

1. Prep area to be patched with 150 grit paper. Lightly sand area until a dull finish is achieved (no shiny spots). Remember we are just roughing up the surface, not trying to remove the entire gel coat. If hand sanding, sand in a circular motion.
2. Using an air nozzle, blow off sanding dust and wipe area clean with virgin acetone and a clean rag.
3. Tape off area to be patched. Keep tapeline slightly inside sanded area.
4. **Warm** the area to be patched using a heat gun. Area should be warm to the touch, not hot.
5. Mix the gel coat and Speed Thin® and catalyze using the following chart. Mix for at least one minute. It is not recommended to mix more than 12 oz.

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	Gel Coat	Speed Thin®	Volume of Mix	Catalyst
Use 150 ml cup }	2 oz.	1 oz.	3 oz.	2.25 ml
	3 oz.	1.5 oz.	4.5 oz.	3.5 ml
Use 400 ml cup }	5 oz.	2.5 oz.	7.5 oz.	5.5 ml
	6 oz.	3 oz.	9 oz.	6.5 ml
	8 oz.	4 oz.	12 oz.	8.5 ml

- Spray the patch mixture. Use a minimum amount of air pressure on the touch-up gun. Do not spray all the way to the tapelines. Keep the edges of the patch feathered.
- Expel liquid patch mixture from gun. Do not flush gun with acetone yet.
- Shake Copper Coat® can.
- Catalyze Copper Coat® using the following chart. Mix for at least one minute.

Copper Coat®	Catalyst
50 ml	1.25 ml
100 ml	2.5 ml
150 ml	3.75 ml

- Mist catalyzed Copper Coat® using same gun as before. Turn down air pressure on touch-up gun until it sprays a fine mist of the Copper Coat®. Apply Copper Coat® like applying “Hairspray” on backside of entire wet patch. **IMPORTANT:** This is just a mist coat. If it runs you have applied too much.
- Thoroughly clean gun.
- Remove tape.
- Allow patch to cure 2.5 hours if external heat is used. If the heat gun is too hot for your hand, it is too hot for the patch. If heat is not used, overnight curing is necessary.
- DO NOT wipe patch with acetone**
- Sand Copper Coat® off using 240 & 500 grit sandpaper.
- Finish sanding with 800 & 1000 grit sandpaper.
- Buff and polish patched area with 3M Imperial compound using 100% wool pad and variable speed electric buffer. Start buffing using slowest speed to allow the compound to “cut” and remove the sanding scratches. Slowly speed up the buffer to polish. It is not necessary to exceed 2500 RPM.
- Inspect area for scratch marks and/or swirl marks. Repeat steps 16 and/or 17 if necessary.

\*Consolidated Plastics Company (1-800-362-1000). 150 ml Part no. 45383LX. 400 ml Part no. 45386LX.

\*\*Kosmetech Corp (718-858-7000). Part no.90009. Consolidated Plastics 25ml graduated cylinder part no. 46332LX also work well for measuring and dispensing catalyst.